

Date: Tuesday, 23/12/2008 1:24:35 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : CLAMP
<b>Job Number</b> : 44315	
<b>Estimate Number</b> : 12805	
<b>P.O. Number</b> :	<b>Part Number</b> : D35561
<b>This Issue</b> : 23/12/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3556 REV.B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 37198	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 05/01/2009 <b>Qty:</b> 50 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev A New Issue 07-03-23 JLM Est Rev B 08-07-28 revB as per dwg (ecn 08-506) DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: 7891

Cut &amp; Form as per Dwg D3556 GFI

Material release note is required

C 08/12/23 (50)

2.0	D35561	Clamp
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

C 9/1/22 (50)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect dimensions

C 09/01/23 (x50) (Pb) -&gt;

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Tumble &amp; Deburr any rough edges

B 9-1-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3550-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: S Date: 09/01/22

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>44315</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
21/1/22	#4.0	During inspection of clamps He $\phi .257" \times 0.357"$ is not within Specs. $0.357$ measures $0.375"$ . Parts were made @ GPI	<u>MP</u> 09/01/22	PARTS ACCEPTABLE	<u>N</u> 1/22	<u>S</u> 09/01/22	<u>MP</u> 09/01/22	<u>S</u> 09/01/22

NOTE: Date & initial all entries

Date: Tuesday, 23/12/2008 1:24:35 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 44315

Part Number: D35561

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/27 *counters* *(+50)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *460*

*21/1/27*

*(50x)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/01/28* *JP*

Job Completion



*u 09.01.28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

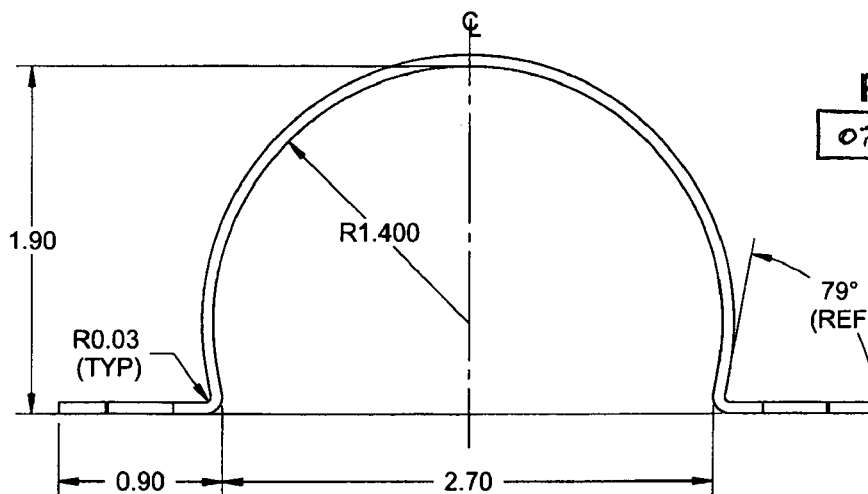
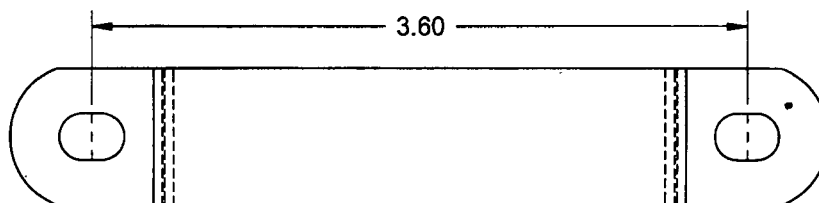
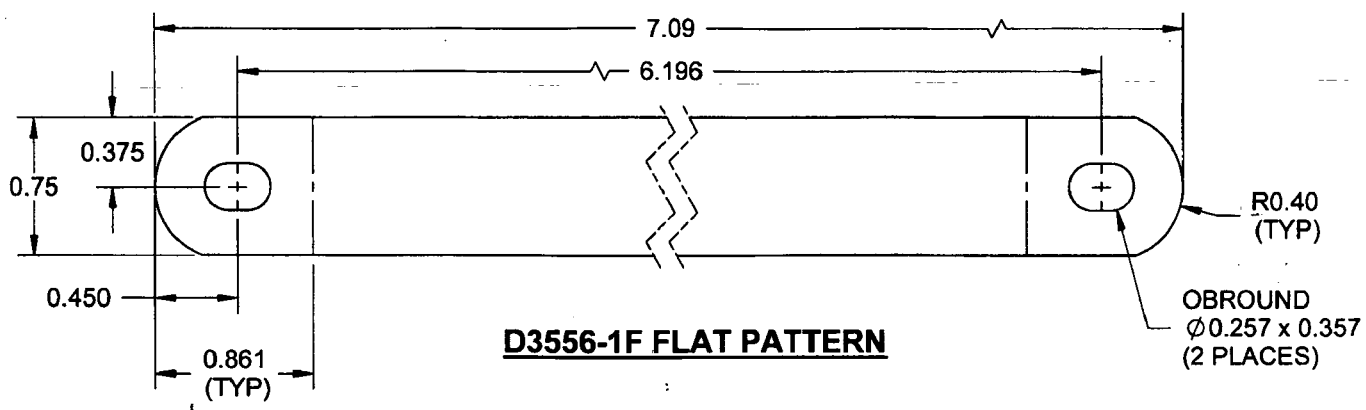
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED A	DRAWING NO. D3556	REV. A SHEET 1 OF 1
DATE 07.02.13		TITLE CLAMP	SCALE 1:1
REV A	DATE 07.02.13	DESCRIPTION NEW ISSUE	



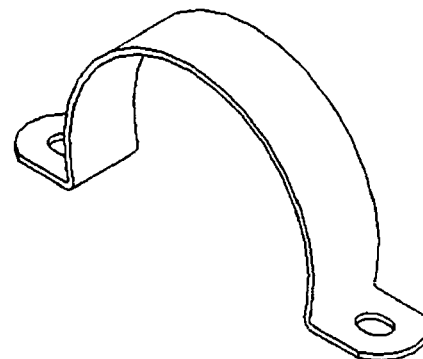
RELEASED

07.03.08

w/o  
44315

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE, PER MIL-S-5019 (REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N D3556-1 USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT  $\phi$



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



180 AVENUE LABROSSE  
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1  
TÉL.: (514) 630-4877 - FAX: (514) 630-4849



# BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2009/01/15	0411752

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VENDEUR / SOLD TO

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON, K6A 1K7

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	A SHIPPED VIA
DART GFI-0299		J0195612	PO00007891	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION		
50	D35561	CLAMP CERTIFICATE OF CONFORMANCE RIQ		

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RECEPTION  
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY

# CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

*Schultz*

CERTIFICATE NO. <u>5</u>		OUR JOB NO. <u>J0195612</u>		SHIPPING MEMO <u>0411752</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME
<u>50 PCS</u>	<u>PO00007891</u>	<u>D35561</u>	<u>A</u>	<u>CLAMP</u>	<u>A</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.	
<u>SST 304</u>		<u>TW METALS / NORTH AMERICAN</u>		<u>H/N # 3TT0</u>	

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>CONFORMS</u>
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 16 JANUARY 2009

G.F. . Q.C. REP.

*Calvin Hank*



DP12-001 REV 0 Bombardier Certificate of Compliance  
TW Metals District Procedure

Revision: 0

Revision Date: 04-03-00

Superseding: Initial

Page: 1 of 1

CERTIFICATE OF COMPLIANCE

FRAUD AND FALSIFICATION STATEMENT

The recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law. Title 18 chapter 47.

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications.

MERCURY FREE STATEMENT

We certify that mercury, radium, or alpha bearing instruments and / or equipment which might cause contamination have not been used in the manufacture, fabrication, assembly or testing of any material supplied by TW Metals Inc. Switches, glass thermometers, standard cell and other items containing the above elements may be used, but they will be located so as not to constitute a contamination hazard.

CUSTOMER NAME:

GFI

PURCHASE ORDER No.

0074934

ITEM No.

0001

SHIPPER INVOICE No.

03243919

MATERIAL:

304-20 STS

SPECIFICATION:

ASTM A 240

MANUFACTURING MILL:

North American Stainless

SIZE:

5062

HEAT / LOT No.

3TT0

PART No.

TS06348X964A

QUANTITY:

1 EA

TEST DEPARTMENT CLERK

Amy Davis

AUTHORITY

Joe Schab

Director of Quality Assurance

S  
02/01/02

This document is maintained as a Controlled Document only in the TW Metals computer system. Once printed, this document immediately becomes Uncontrolled and is subject to change at any time and without notice.

Authorized Signature

Lynne Harper



NORTH AMERICAN  
STAINLESS

# METALLURGICAL TEST REPORT

Certificate: 392189 03

Customer: 0018 001

6870 Highway 42 East  
Ghent, KY 41045-9615  
(502) 347-6000

Date: 4/03/2008 Page: 1

Steel: 102/104/306L

Finish: 2B

Corrosion: ASTM A276/A276-2, 1998 and OK

Your Order: 01012012

NAS Order: AN 0391527 01

## PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, COLD ROLLED, ANNEALED AND PICKLED.  
ASTMA340/07, 480/06b, 666/03, ASME SA340/04-A05, 480/04-A05, SA666/04  
QQ8766D-AMG FRM, AMS5511H/5511H/5516P, AND 3.X CROWN WEAR

## REMARKS:

Mat'l Free of Mercury Contamination. No weld repairs.  
EN 10204 3.1, QQ8761F Cond A, RoHS Compliant  
\* Melted & Manufactured in the USA

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Flange	CORROSION CODE
013770 B	013770 B	.0410	36.0000	19.540 COIL	2542.0	11	1	

## CHEMICAL ANALYSIS

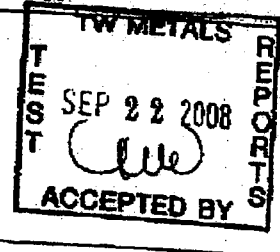
Heat	CR	C	CR	CU	NI	N	HT	P	S	BT
2770	.0244	19.2154	.4134	1.8031	.3728	.0104	0.2663	.0450	.0031	.3511

## MECHANICAL PROPERTIES

Product ID #	Coil #	Y T	UTS	EL	HAZ	Hard	Tell
013770 B	041770	84.55	51.70	48.57	89.00	84.00	

REVIEWED BY Q.C.

Date 4/18/08 By [Signature]



NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

QC ENGINEER

ERIC HESS

4/17/2008

36 X 96  
P.O.: P0009225  
Sales#: 01116428  
QTY: 5

Size: 304L AMN .060-.066 AMS 5511  
Customer: TW Metals Pick Up  
Heat: J770  
Shipped: 09/18/08 M49202123